

Date: Wednesday, 12/5/2007 12:54:05 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: FLOAT SKIDTUBE		
Job Number	: 35922			Part Number	: D412742011		
Estimate Number	: 12877			Drawing Number	: N/A		
P.O. Number	:			Project Number	: N/A		
This Issue	: 12/5/2007 S.O. No. :			Drawing Revision	: P/A		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : LANDING GEAR			Due Date	: 1/10/2008 Qty: 1 Um: Each		
Previous Run	: 35921						
Written By	:						
Checked & Approved By	: <u>John D. 12/05</u>						
Comment	: Est Rev: A 05.10.13 New Issue KJ/JLM						
	Est Rev:B 06-06-08 As per DS19336 JLM						
	Est Rev:C 07-05-28 As per Rev C JLM						
	est rev D 07.11.01 ecn 1053P EC						
	est rev E 07.11.27 ecn 1072 EC verified by:DD						



Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	<i>0861/29</i> <i>k-SD7. 12.12</i>
		Comment: DOCUMENT CONTROL Photocopy bluefile and create labels per PPP D412-742-011 CHG008 004 (per GCN 1104 & 08.0414)	
2.0	35922A	FLOAT SKID ASSEMBLY	
		Comment: Sub-Component FLOAT SKID ASSEMBLY D412-742-041 B <i>35922A</i> <i>SD</i>	
3.0	D412742015	Electric Step Kit	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Electric Step Kit Batch: <i>137040</i> <i>SD</i>	
4.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Pick Packing Kit	
5.0	D2571	Saddle, Fwd, Out	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) SADDLE batch: <i>35931</i> <i>81/29 SD 1x</i>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Seq. #:	Machine Or Operation:	Description :
6.0	D2572	Saddle, Fwd, In
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)		
SADDLE batch: <i>135932</i>		
7.0	D2573	Saddle, Aft, Out
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)		
SADDLE batch: <i>135933</i>		
8.0	D2574	Saddle, Aft, In
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)		
SADDLE batch: <i>136325</i>		
9.0	D2876	Saddle Spacer
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)		
SADDLE SPACER batch: <i>1333543</i> <i>(X)</i> <i>36543</i> <i>(X)</i> <i>136276</i> <i>(X)</i> <i>SO</i>		
10.0	D2877	Saddle Spacer
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)		
SADDLE SPACER batch: <i>136276</i>		
11.0	D34031	Bushing
Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)		
BUSHING batch: <i>135634</i>		
12.0	D2747	Set Screw
Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)		
Set Screw batch: <i>135758</i>		

W/O:		WORK ORDER CHANGES					
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Job Number:		
Seq. #:	Machine Or Operation:	Description :
13.0	D35331	Set Screw
		
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Set Screw BATCH: <i>138093</i> <i>324093</i> <i>50</i>	
14.0	AN4C6A	Bolt
		
	Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s) BOLT batch: <i>M105793</i> <i>50</i>	
15.0	AN4C52A	BOLT
		
	Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s) BOLT batch: <i>M19512</i> <i>50</i>	
16.0	AN6C12A	BOLT
		
	Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s) BOLT batch: <i>M104289</i> <i>50</i>	
17.0	D36723	PHENOLIC WASHER
		
	Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s) PHENOLIC WASHER batch: <i>A106134471</i> <i>50</i>	
18.0	AN960C416L	WASHER
		
	Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s) WASHER batch: <i>M105793</i> <i>50</i>	
19.0	D36729	PHENOLIC WASHER
		
	Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s) PHENOLIC WASHER batch: <i>A135523</i> <i>8/1/2950</i> <i>6</i>	

W/O:		WORK ORDER CHANGES					
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Job Number: 35922		Part Number: D412742011
Job Number:		
Seq. #:	Machine Or Operation:	Description :
20.0	AN960C616L	WASHER
Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s) WASHER batch: M18918		SQ
21.0	D367211	PHENOLIC WASHER
Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s) PHENOLIC WASHER batch: B335524		SQ
22.0	MS210434	Nut
Comment: Qty.: 29.0000 Each(s)/Unit Total : 29.0000 Each(s) NUT batch: M106576 (2x) M101390 (4x) M102039 (2x) M104936 (2x) M105115 (1x)		M
23.0	AN4C7A	Bolt
Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Bolt Batch: M101427		SQ
24.0	AN3C37A	BOLT
Comment: Qty.: 3.0000 EACH(s)/Unit Total : 3.0000 EACH(s) BOLT batch: M106171		SQ
25.0	AN3C40A	BOLT
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) BOLT batch: M106169		81,1/29 SQ (1x)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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QA: N/C Closed: _____ Date: _____

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Job Number: 35922		Part Number: D412742011
Job Number:		
Seq. #:	Machine Or Operation:	Description :
26.0	AN3C41A	BOLT
Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s) BOLT batch: M106169		SP
27.0	AN3C42A	BOLT
Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s) BOLT batch: M106169		SP
28.0	AN3C43A	BOLT
Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s) BOLT batch: M106299		SP
29.0	AN3C44A	BOLT
Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s) BOLT Batch: M106187		SP
30.0	AN3C47A	BOLT
Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s) BOLT Batch: M106171		SP
31.0	AN960C10L	washer
Comment: Qty.: 66.0000 Each(s)/Unit Total : 66.0000 Each(s) washer batch: M106552		SP
32.0	MS210433	Nut
Comment: Qty.: 33.0000 Each(s)/Unit Total : 33.0000 Each(s) Nut batch: M106781 23X		8/1/29 SP (X)

W/O:		WORK ORDER CHANGES					
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QA: N/C Closed: _____ Date: _____

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Job Number: 35922	Part Number: D412742011
Job Number:	
Seq. #:	Machine Or Operation:
33.0	D34033 Bushing
Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s) BUSHING batch: <i>B34563 3x B35635 5x</i>	
34.0	D3405041 Lug Assembly
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) GHW LUG batch: <i>B35779</i>	
35.0	D3405043 Lug Assembly
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) GHW LUG batch: <i>B34841 B34841 50</i>	
36.0	AN4C46A BOLT
Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) BOLT batch: <i>M19529 SC0</i>	
37.0	D3407041 Tow Ring
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) TOWRING batch: <i>B35780 SC0</i>	
38.0	D34173 Washer
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) WASHER batch: <i>B33519 SC0</i>	
39.0	D34561 washer
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) WASHER batch: <i>B33276 81/129 SC0 R</i>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 08/01/09
 QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number: 35922	Part Number: D412742011	
Job Number:		
Seq. #:	Machine Or Operation:	Description :
40.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
		<i>✓ 08/01/29 (40)</i>
Comment: INSPECT 100% KITS FOR COMPLETENESS		
41.0	PACKAGING 1.	PACKAGING RESOURCE #1
		<i>✓ 08/01/29 (1)</i>
Comment: PACKAGING RESOURCE #1 Identify and pack for shipping as per PPP D412-742-011 Location: <i>✓ 08/01/29 (1)</i>		
42.0	QC21	FINAL INSPECTION/W/O RELEASE
		<i>✓ 08/01/29 (1)</i>
Comment: FINAL INSPECTION/W/O RELEASE <i>✓ 08/01/29</i>		
Job Completion		
<i>✓ 08/01/29</i>		
<p>POSITIVE RECALL EFFECTIVE <u>07/21/14</u> AUTH <u>4</u> RELEASED <u>✓</u> DATE <u>08/01/29</u></p> <p><i>B35922</i></p>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	FLOAT SKID ASSEMBLY		
Job Number	35922A			Part Number	D412742041		
Estimate Number	12876			Drawing Number	D3391 REVG		
P.O. Number				Project Number	N/A		
This Issue	12/5/2007	S.O. No.	:	Drawing Revision	<i>D</i>		
Prsh Rev.	NC			Material	:		
First Issue	/ /	Type	LANDING GEAR	Due Date	1/10/2008	Qty:	1
Previous Run	35921A			Um:	Each		
Written By	<i>JL</i>						
Checked & Approved By	<i>JL</i> 12/05						
Comment	Est Rev A 05.10.13 New Issue Est Rev B 06.02.13 ECN 773 dwg @ rev.D Est Rev:C 07-05-28 As per Rev F EST rev D 07.11.01 ecn 1053p est rev E 07.11.27 ecn 1072 by:DD			KJ/JLM			
				EC			
				JLM			
				EC			
				EC verified			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
2.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: DOCUMENT CONTROL

If D412-742-041 is a W/O on its own,
 Photocopy bluefile and create labels per PPP D412-742-041 CHG003

NIA

Comment: HAND FINISHING RESOURCE #1

1-Spray inside tube of D3391-021/-023/-025 with LPS-3 as per Dwg D3391

A/R LPS-3 *M106096*

2-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins.

A/R Sikaflex-241/-291 *M105585*Expiry date: *08/07*

3-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Coat bolts with LPS "procyon".

Seal all bolts with sikaflex except ones with inserts on inside of tube ,hand tighten only bolts with no sikaflex.

A/R LPS Procyon *M104251*A/R Sikaflex-241/-291 *(28/07)* *M105585*Expiry date: *08/07*

4-Remove "T" pins once sikaflex is dry.

5-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser.

m.f.
08/01/28

W/O:		WORK ORDER CHANGES					
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 35922A

Part Number: D412742041

Job Number:



Seq. #: Machine Or Operation:

Description :

3.0 D3391013 Mid Tube Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

Qty Part Number Description Batch
1 D3391-013 Mid Tube Assembly

B36807

4.0 D3391015 Aft Tube Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

Qty Part Number Description Batch
1 D3391-015 Aft Tube Assembly

B33476

5.0 D35641 WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch:

B33798

M.J.

6.0 D35643 WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch:

B33801

M.J.

7.0 D35645 WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch:

B36338

M.J.

8.0 D35661 GASKET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

GASKET

Batch:

B36112

M.J. 08/01/28

W/O:		WORK ORDER CHANGES					
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Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 35922A

Part Number: D412742041

Job Number:



Seq. #: Machine Or Operation:

Description :

9.0 D35665 GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

B36113

m.f

10.0 AN3C4A BOLT



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

BOLT

M106785

m.f

11.0 AN3C6A BOLT



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

BOLT

M105057

m.f

12.0 AN3C7A BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

BOLT

M105906

m.f

13.0 AN960C10L washer



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

washer

M106552

m.f

14.0 MS27039C412 SCREW



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

SCREW

M106720

m.f

15.0 D36723 PHENOLIC WASHER



(X)

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

washer

B34471

m.f 08/01/28

W/O:		WORK ORDER CHANGES					
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Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 35922A

Part Number: D412742041

Job Number:



Seq. #: Machine Or Operation:

Description :

16.0 AN960C416L WASHER



X

Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

WASHER

Batch:

M106993

M. h

17.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

18.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-742-041

Location: _____

PPP Rev: _____

PPP 35922

12/29/07

①

19.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

12/29/07

Job Completion



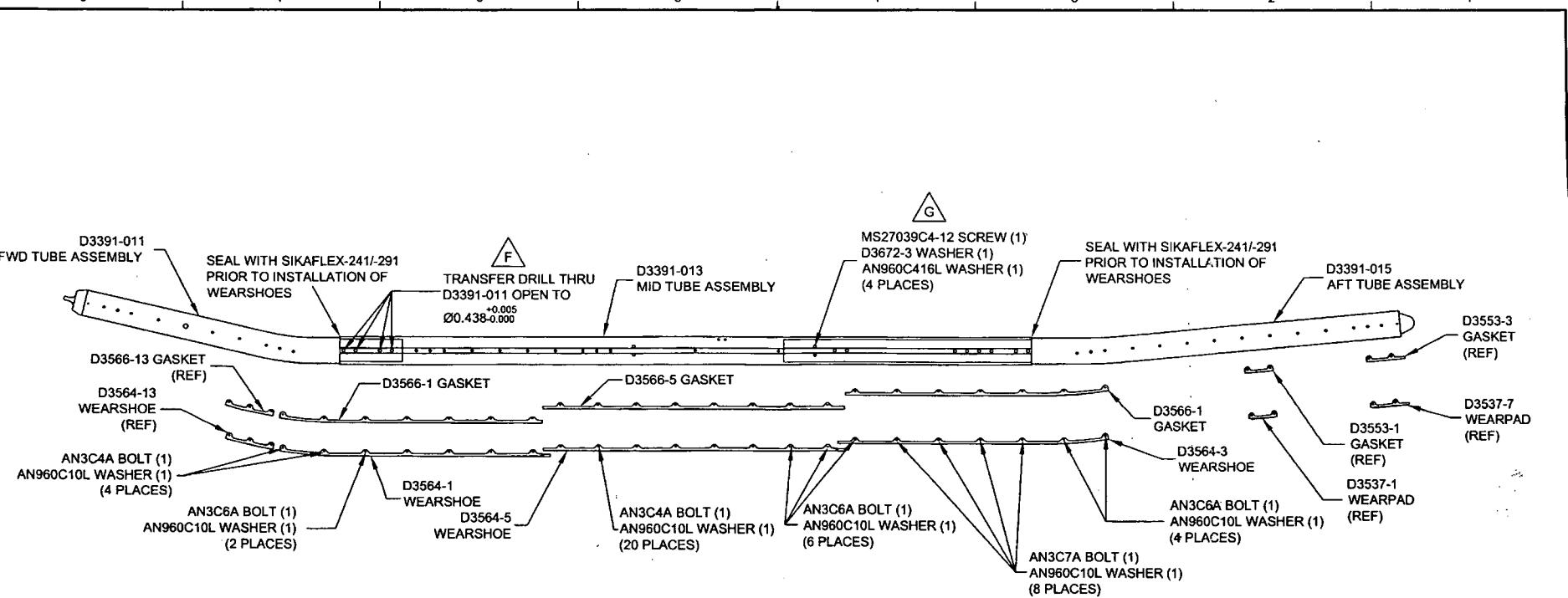
12/29/07

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NOTE: Date & initial all entries



RELEASED
07-11-06

D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
4	D3672-3	WASHER
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

UNCONTROLLED COPY
NO WORK ORDER
SUBJECT TO AMENDMENT
3) 4) ENGINEERING
COPY
RETURN TO
REF ID: 155224

GENERAL NOTES

- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
UNITS: INCHES UNLESS OTHERWISE NOTED
USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

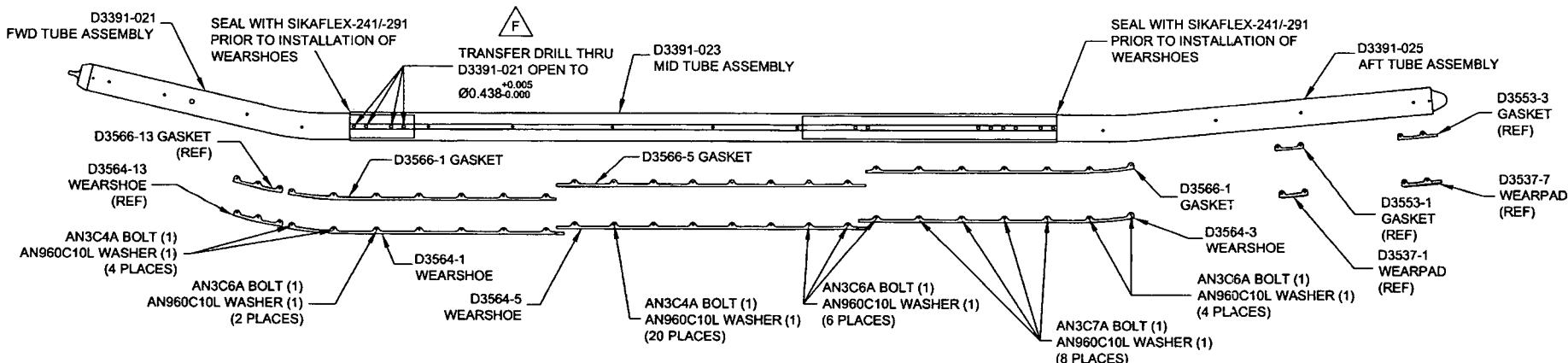
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PH</i>	DART AEROSPACE USA, INC	
DRAWN	<i>SC</i>	PORT HADLOCK, WA	
CHECKED	<i>AB</i>	DRAWING NO.	REV. G
MFG. APPR.	<i>SC</i>	D3391	SHEET 1 OF 8
APPROVED	<i>SC</i>	TITLE	SCALE
DE APPR.	<i>SC</i>	412 FLOAT SKIDTUBE	NTS
DATE	07.07.31	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC	

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RELEASED
07-11-02 10

D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
1	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
24	AN524A	BOLT
12	AN524B	BOLT
8	AN3C7A	BOLT
44	AN960C1G1	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

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MFG. APPR.	<i>RJG</i>	D3391	SHEET 2 OF 8	
APPROVED	<i>JW</i>	TITLE	SCALE	
DE APPR.	<i>JW</i>	412 FLOAT SKIDTUBE	NTS	
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